

Date: Wednesday, 4/26/2006 12:32:22 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHUT-OFF VALVE BRACKET
Job Number : 26855	
Estimate Number : 12256	
P.O. Number : N/A	Part Number : D3481041
This Issue : 4/26/2006 S.O. No. : N/A	Drawing Number : D3481 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 26184	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 4/28/2006 Qty: 1 Um: Each
Checked & Approved By : SEE ABOVE USER & DATE	
Comment : Est Rev: A New Issue 06-02-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D3481043	bracket & clamp ass'y
-----	----------	-----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3481-3043	Bracket Assembly	

PTO

inspect level 5/9 SB 106/04/27 (2)

2.0	BACN10YD3	CLIP FLOATING NUT
-----	-----------	-------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	BACN10YD3	Clip	M19596

Bacn 10YD3

3.0	AN33A	Bolt
-----	-------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-3A	Bolt	M18310

Bacn 33A

4.0	AN96010	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN960-10	Washer	M5579

Bacn 96010

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/04/27		Fabricate D3481-043 by hand as per drawing Fabricate D3481-3 by hand 304/316 SS M19704 Q5200M445 M100202	B	06/04/27	1	B 06/04/27	B 06/04/27

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: B Date: 06/04/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/26/2006 12:32:22 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE BRACKET

Job Number: 26855

Part Number: D3481041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34811

ANGLE BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3481-1

Bracket

1326/05

18 count 2

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3481

18 count 2

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/04/27 1

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a fine point permanent marker and Stock

Location: 443

12/9/28 1

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/28

Job Completion



06-04-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

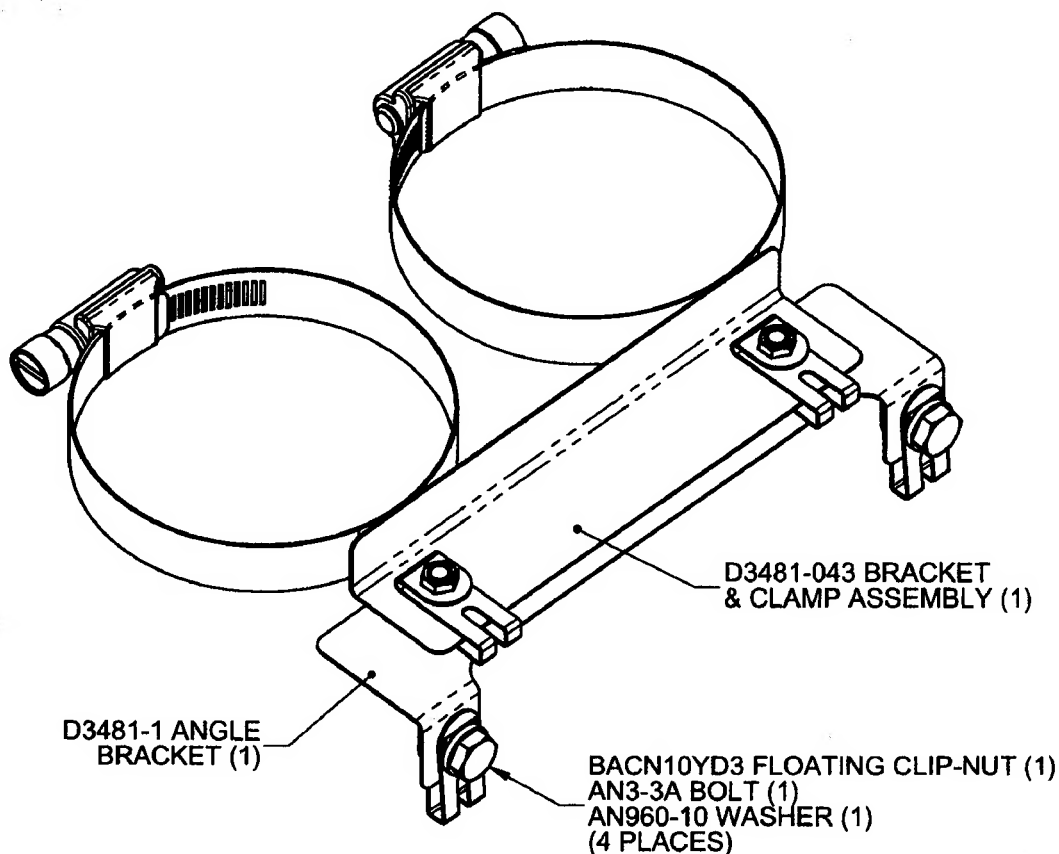
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3481	REV. A SHEET 1 OF 4
DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 2:3
A	06.01.23	NEW ISSUE	

[Signature] 06.04.03



D3481-041 SHUT-OFF VALVE BRACKET

1) IDENTIFY WITH DART P/N D3481-041 USING FINE POINT PERMANENT INK MARKER

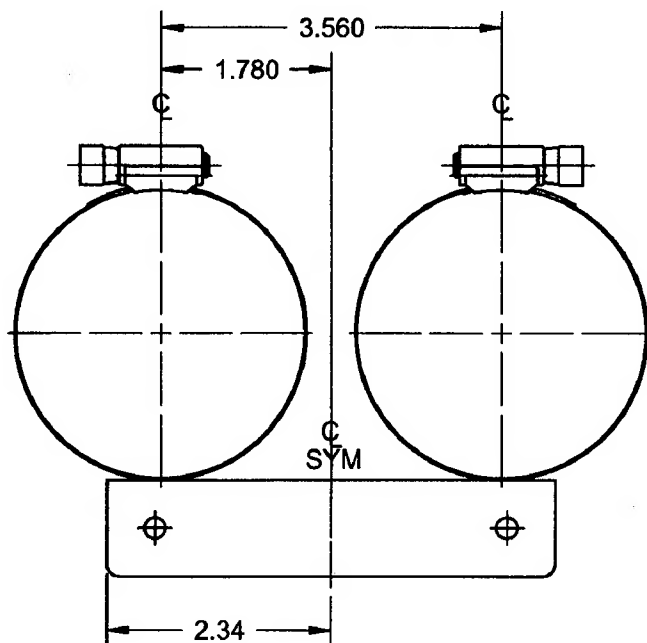
QTY -041	P/N	DESCRIPTION
X	D3481-041	SHUT-OFF VALVE BRACKET
1	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-1	ANGLE BRACKET
4	AN3-3A	BOLT
4	AN960-10	WASHER
4	BACN10YD3	FLOATING CLIP-NUT

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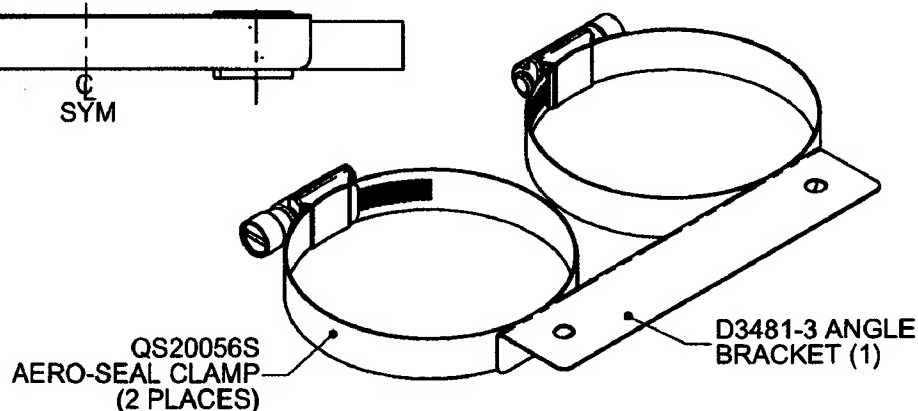
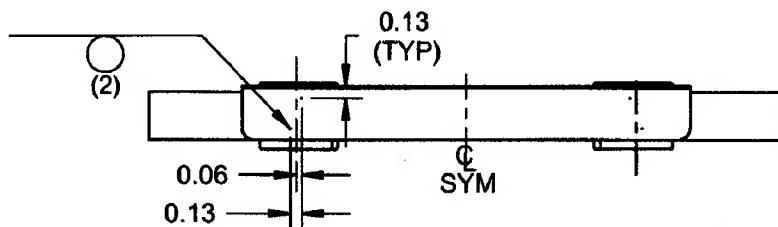
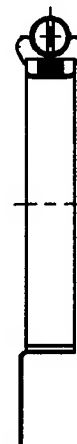
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DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2



[Signature] 06.04.03



D3481-043 BRACKET & CLAMP ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

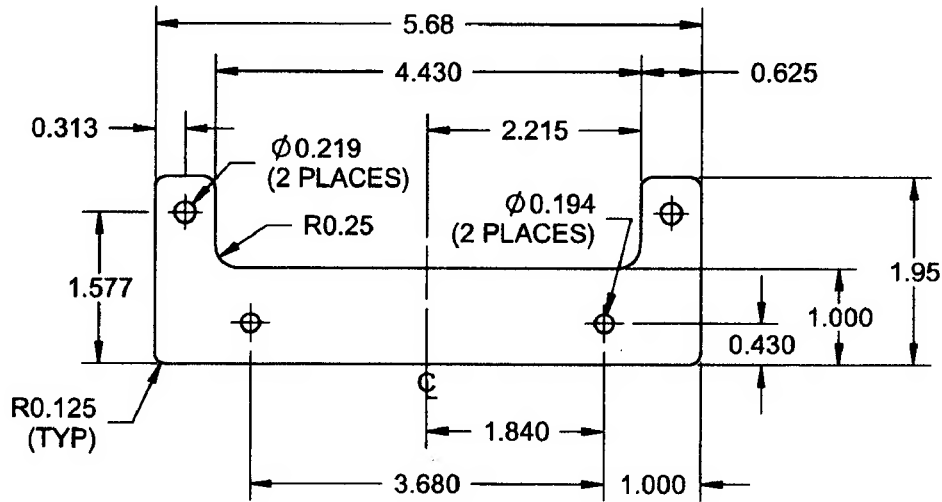
QTY -041	P/N	DESCRIPTION
X	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-3	ANGLE BRACKET
2	QS20056S	AERO-SEAL CLAMP

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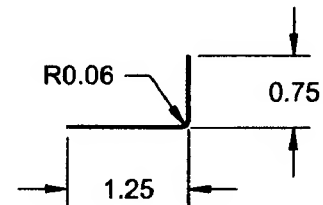
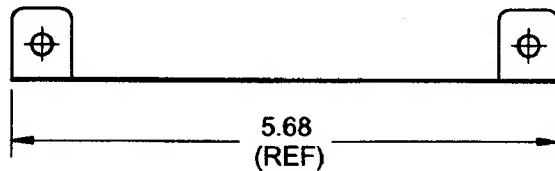
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DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2

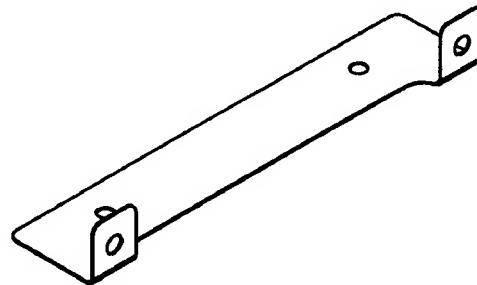


D3481-1F FLAT PATTERN



D3481-1 ANGLE BRACKET

[Signature] 06.04.03



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

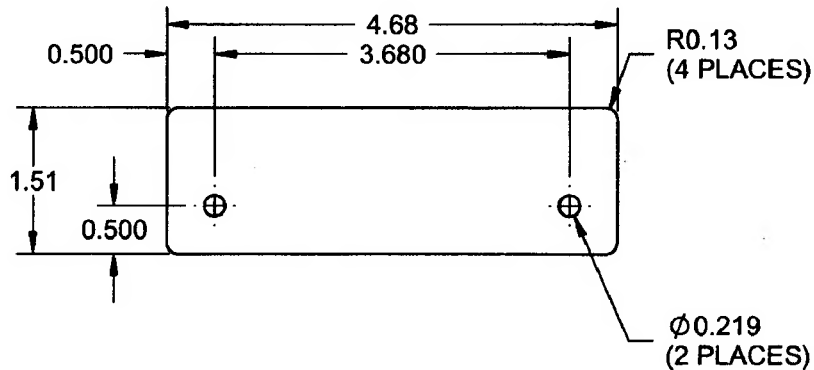
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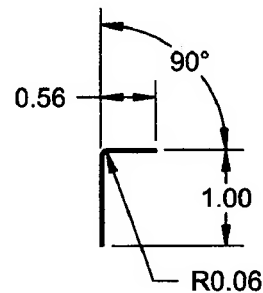
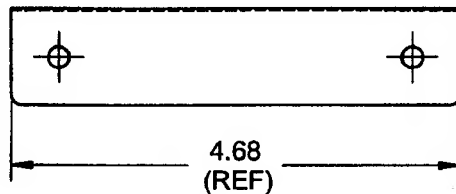


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DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2

[Signature] 06.04.03



D3481-3F FLAT PATTERN



D3481-3 ANGLE BRACKET

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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